

Work Order ID 56837

March 10, 2010 3:51:37 PM



Page 1

Item ID:	D3773-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Headrest Assembly				Stop	
Start Date:	10/03/2010	Start Qty:	6.00			
Required Date:	17/03/2010	Req'd Qty:	6.00			
Reference:						

Approvals:	Process Plan:	<i>RF</i>	Date:	<i>10-3-10</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3773	Rev B								

100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

EL 10-4-5 (X6)

110	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1- locate top hole with a 3/16" dowel pin and tack weld D3773-1 adapter to D3773-3 leg as per dwg D3773 ****take dowel pin out before welding**** 2- weld as per dwg D3773 QSI004 316 S.S. Welding Rod								
	Batch: <i>M108160</i> 3- if necessa								

EL 10-4-5 (X6)

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

6/6/07

(13) f3 Ph =>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3773-3 D3773-041 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: 1 Date: 16-04-07
B56862
Resolution: Scrap Disposition: Scrap QA: N/C Closed: 16/04/12 Date: 16/04/12

NCR: <u>56837</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>16/04/07</u>	<u>#120</u>	<u>During inspection Found that QTY x3 welds assembly donot correspond to Dwg's. the .201" hole doesn't line up with the .257" holes</u>	<u>[Signature]</u> <u>B51042</u>	<u>-Scrap & Destroy QTY x3 parts that have D3773-3 B56862 welded to them.</u> <u>- No Replace (will replace on new w/o)</u>	<u>EL</u> <u>10-4-6</u>	<u>S</u> <u>16/04/07</u>	<u>[Signature]</u> <u>B51042</u>	<u>S</u> <u>16/04/06</u>
		<u>- welder didn't notice the problem before welding D3773-1 to D3773-3. R.C D3773-3 B56862 were machined wrong & inspected</u>	<u>[Signature]</u> <u>B51042</u>	<u>- Pull w/o + other D3773-3 B56862 that was machined that is in stock + scrap</u>	<u>EL</u> <u>10-4-6</u>	<u>S</u> <u>16/04/07</u>	<u>[Signature]</u> <u>B51042</u>	<u>S</u> <u>16/04/06</u>
		<u>R.C I.D.A</u>	<u>[Signature]</u> <u>B51042</u>	<u>- Retrain both parties involved to be more attentive to Dwg when inspecting.</u>	<u>E</u>		<u>[Signature]</u> <u>B51042</u>	<u>S</u> <u>16/04/06</u>

NOTE: Date & initial all entries

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Item ID: D3773-041

Accept



Setup Start



Revision ID:

Item Name: Headrest Assembly

Stop



Start Date: 10/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.04.05.

140

Identify as per dwg & Stock Location: ST192

0.00



Packaging

Memo

0.00

Packaging

Packaging (3)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/12

U 1004.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

28

Picklist Print

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Page 1

Work Order ID: 56837

Parent Item: D3773-041

Parent Item Name: Headrest Assembly


Start Date: 10/03/2010

Required Date: 17/03/2010

Comments: IPP Rev:A 08-05-21 new issue DD verified by:ec
 IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3773-1		Manufactured	No			100	Each	8.0000	6.0000			
												
Adapter												

E2 10-4-5

Warehouse
Location

Main Warehouse

ST

8

54799

8

D3773-3

Manufactured No

110

Each

4.0000

6.0000

6



Leg



E2 10-4-5

Warehouse
Location

Main Warehouse

ST

4

40997

1

54800

3

56862

3

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

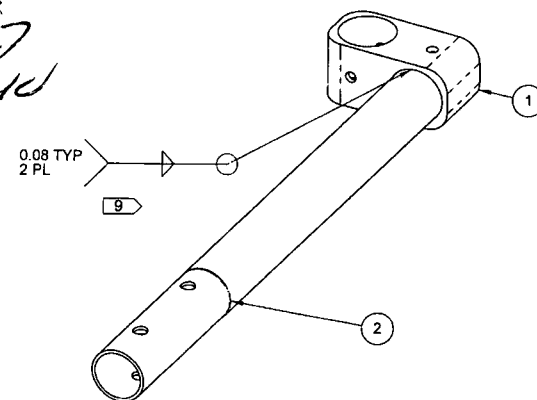
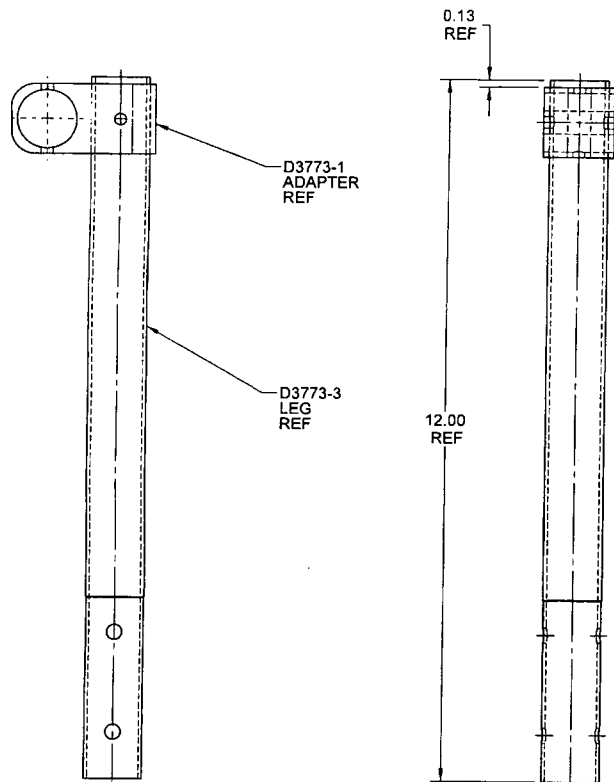
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *36837*
PH-0-3-K



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D3773-1	ADAPTER	1
2	D3773-3	LEG	1

NOTES:

- 1) MATERIAL: SEE D3773-1/-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3773-1, 0.40 lbs
D3773-3, 0.69 lbs
D3773-041, 1.04 lbs
- 8) WELD: PER DART QSI 004
- 9) IF NECESSARY GRIND INTERIOR OF D3773-3 LEG FLUSH AFTER WELDING

D3773-041 HEADREST ASSEMBLY

B	CHANGE HOLE SIZE TO 0.201	HS	08.06.24
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	HS		
CHECKED	<i>PH</i>		
MFG. APPR.	<i>PH</i>		
APPROVED	<i>PH</i>		
DE APPR.	<i>PH</i>		
DATE	08.06.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3773** REV. B
SHEET 1 OF 3
TITLE **HEADREST ADAPTER** SCALE NTS

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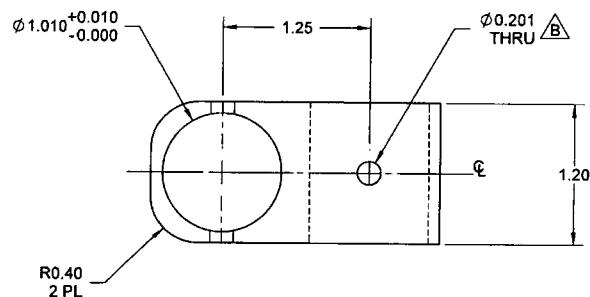
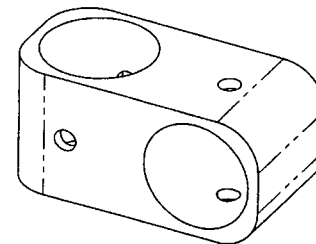
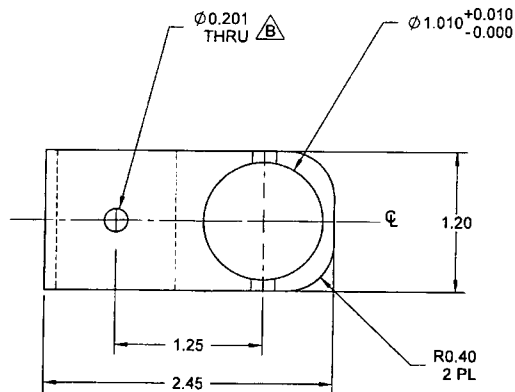
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3773-1 ADAPTER

NOTES:

- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3773	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	HEADREST ADAPTER	NTS
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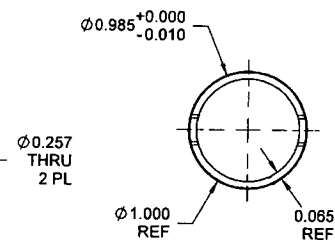
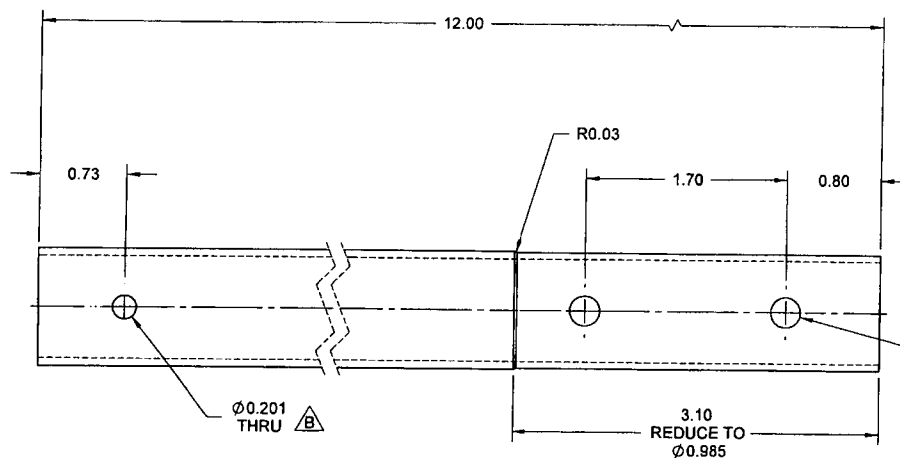
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D3773-3 LEG

- NOTES:
- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.69 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED	HS	DRAWING NO. REV. B
MFG. APPR.	HS	D3773 SHEET 3 OF 3
APPROVED	HS	TITLE SCALE
DE APPR.	HS	HEADREST ADAPTER NTS
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